

WHAT IS CLAIMED IS:

1. A brake drum for a wet-type band brake having a large number of grooves substantially along the circumferential direction on a slide contact  
5 surface with the brake band, wherein:

each adjacent grooves are smoothly linked to each other through a substantially convex arcuate cross sectional-portion.

10 2. A brake drum for a wet-type band brake having a large number of grooves substantially along the circumferential direction on a slide contact surface with the brake band, wherein:

a land is formed between each adjacent grooves  
15 and said land and said grooves are smoothly linked to each other through a substantially convex arcuate cross sectional-portion.

3. A rotatory drum for a wet-type brake band  
20 according to Claim 1 or 2, wherein said grooves are formed by cutting work while said substantially convex arcuate cross sectional-portion is formed by rolling process.

25 4. A rotatory drum for a wet-type brake band according to Claim 1 or 2, wherein said grooves and said substantially convex arcuate cross sectional-

portion are both formed by rolling process.

5           5. A brake drum for a wet-type band brake according to Claim 1 or 2, wherein said grooves are formed at a pitch of 0. 05mm to 0. 3mm in a dimensional range of 0. 5 $\mu$ m to 50 $\mu$ m in depth and of 0. 05mm to 0. 3mm in width.

10           6. A brake drum for a wet-type band brake according to Claim 3, wherein said grooves are formed at a pitch of 0. 05mm to 0. 3mm in a dimensional range of 0. 5 $\mu$ m to 50 $\mu$ m in depth and of 0. 05mm to 0. 3mm in width.

15           7. In a method for manufacturing a brake drum for a wet-type band brake having a large number of grooves substantially along the circumferential direction on a slide contact surface with the brake band, a method for processing the surface of the  
20       brake drum comprises the steps of:

          forming the grooves by cutting work; and

          forming a border portion between each adjacent grooves in a substantially convex arcuate cross section by plastic working using a forming roller.

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          8. In a method for manufacturing a brake drum for a wet-type band brake having a large number of

grooves substantially along the circumferential direction on a slide contact surface with the brake band, a method for processing the surface of the brake drum comprises the steps of:

- 5           forming the grooves by cutting work; and  
          forming a border portion between a land existing between each adjacent grooves and said grooves in a substantially convex arcuate cross section by plastic working using a forming roller.

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9. In a method for manufacturing a brake drum for a wet-type band brake having a large number of grooves substantially along the circumferential direction on a slide contact surface with the brake band, a method for processing the surface of the  
15       brake drum comprises the steps of:

- forming said grooves and, at the same time, forming a border portion between each adjacent grooves in a substantially convex arcuate cross  
20       section by plastic working using a forming roller.

10. In a method for manufacturing a brake drum for a wet-type band brake having a large number of grooves substantially along the circumferential  
25       direction on a slide contact surface with the brake band, a method for processing the surface of the brake drum comprises the steps of:

forming said grooves and, at the same time,  
forming a border portion between a land existing  
between each adjacent grooves and said grooves in a  
substantially convex arcuate cross section by plastic  
5 working using a forming roller.

11. A method for processing the surface of a  
brake drum for a wet-type band brake according to any  
one of Claims 7 to 10, wherein said grooves are formed  
10 at a pitch of 0. 05mm to 0. 3mm in a dimensional range  
of 0. 5µm to 50µm in depth and of 0. 05mm to 0. 3mm in  
width.